

DART
AEROSPACE
S015486

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Hard Point Adapter, RH

PART NO: D4893-2

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/29/17

Job No: 168172



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D4893-2
Job Sheet 168172



Part No: D4893-2

Job Qty: 6 Ea

Part Name: Hard Point Adapter, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/10/17

Job Tracking No:

Due Date: 12/27/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Pacific Helicopters Pty - Asia Pacific (CPACI02)

PO Box 342, Goroka, Eph Papua, , 441 Papua New Guinea ph:011 675 732 1833 fx:011 (675) 5321503.

Note: DWG REV A IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/26/17	0.00	0.00	Start Up Machining		
100	Bandsaw	6 pcs		12/26/17	0.00	0.00	Bandsaw1		
110	CNC Vertical Machining	6 pcs		12/26/17	3.09	7.32	HAAS 1		
130	QC	6 pcs		12/26/17	0.00	0.00	QC8		
140	HandFinish	6 pcs		12/26/17	0.00	0.41	HandFinish1		
150	QC	6 pcs		12/26/17	0.00	0.00	QC7		
151	Powdercoat	6 pcs		12/27/17	0.00	0.21	Powdercoat1		
155	QC	6 pcs		12/27/17	0.00	0.00	QC3		
170	Packaging	6 pcs		12/27/17	0.00	0.00	Packaging3		
180	QC21-SA	6 Ea		12/27/17	0.00	0.00	QC21		

Part Op 100 - Cut blank 3.375" long

Descriptions: 110 - 1- Machine as per Folio FB193 and Dwg D4893

151 - MASK AS PER NOTE 9

M138467 START: 4:30 OUT: 3:00 FINISH: 5:00

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B2.000X05.000 m136200 = 4.62	2	10	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hardpoint Adaptr, RH	72.000Degrees ± 0.500	72.500 71.500	Angle	
2	Hardpoint Adaptr, RH	1.500Inches ± 0.030	1.530 1.470		
3	Hardpoint Adaptr, RH	0.030Inches ± 0.030	0.060 0.000		
4	Hardpoint Adaptr, RH	45.000Degrees ± 0.500	45.500 44.500	Angle	
5	Hardpoint Adaptr, RH	2.450Inches ± 0.030	2.480 2.420		
6	Hardpoint Adaptr, RH	1.300Inches ± 0.030	1.330		

			1.270	
7	Hardpoint Adaptr, RH	0.750Inches ± 0.030	0.780 0.720	
8	Hardpoint Adaptr, RH	2.500Inches ± 0.005	2.505 2.495	
9	Hardpoint Adaptr, RH	1.250Inches ± 0.005	1.255 1.245	
10	Hardpoint Adaptr, RH	0.250Inches ± 0.030	0.280 0.220	Radius
11	Hardpoint Adaptr, RH	0.500Inches ± 0.030	0.530 0.470	
12	Hardpoint Adaptr, RH	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter
13	Hardpoint Adaptr, RH	0.204Inches + 0.005 - 0.001	0.209 0.203	Diameter
14	Hardpoint Adaptr, RH	1.500Inches ± 0.030	1.530 1.470	
15	Hardpoint Adaptr, RH	1.000Inches ± 0.030	1.030 0.970	
16	Hardpoint Adaptr, RH	1.000Inches ± 0.030	1.030 0.970	
17	Hardpoint Adaptr, RH	0.130Inches ± 0.030	0.160 0.100	Radius
18	Hardpoint Adaptr, RH	0.830Inches ± 0.030	0.860 0.800	
19	Hardpoint Adaptr, RH	0.100Inches ± 0.030	0.130 0.070	
20	Hardpoint Adaptr, RH	45.000Degrees ± 0.500	45.500 44.500	Angle
21	Hardpoint Adaptr, RH	1.750Inches ± 0.030	1.780 1.720	
22	Hardpoint Adaptr, RH	1.460Inches ± 0.030	1.490 1.430	
23	Hardpoint Adaptr, RH	1.650Inches ± 0.030	1.680 1.620	
24	Hardpoint Adaptr, RH	4.000Inches ± 0.030	4.030 3.970	
25	Hardpoint Adaptr, RH	0.250Inches ± 0.030	0.280 0.220	
26	Hardpoint Adaptr, RH	45.000Degrees ± 0.500	45.500 44.500	Angle
27	Hardpoint Adaptr, RH	0.750Inches ± 0.010	0.760 0.740	
28	Hardpoint Adaptr, RH	1.015Inches ± 0.010	1.025 1.005	Diameter

Plex 11/10/17 10:54 AM dart.poulin.mario

D4893-1 HARDPOINT ADAPTER, LH
D4893-2 HARDPOINT ADAPTER, RH OPPOSITE

SECTION A-A B7-1

